

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018124**Date Inspected:** 14-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

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This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SB021-098-019 located on Suspender Bracket SB098E. ZPMC Welder is identified as 058792. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2231-Tc-U4b-F.

FCAW welding of weld joint SB027-110-088, 099 located on Suspender Bracket SB110. ZPMC Welder is identified as 062755. ABF Quality Control (QC) is identified as Mr. Peng Wen Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2232-Tc-U4b-F.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on stringer plate of the OBG Bike Path BK004B-001.

FCAW welding of weld joint BK004A1-007-005, 006 001 and 004 located on sole plate OBG of Bike Path. ZPMC Welder is identified as 062762. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

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FCAW welding of weld joint BK004A1-007-008, 010, 013 and 038 located on sole plate of OBG of Bike Path. Welder is identified as 062788. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint BK004A1-009-030, 031, 032, 033, 034, 035, 036, 037, 039, 040, 041 and 042 located on clip plate of OBG of Bike Path. Welder is identified as 062761. ZPMC Quality Control (QC) is identified as Mr. Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

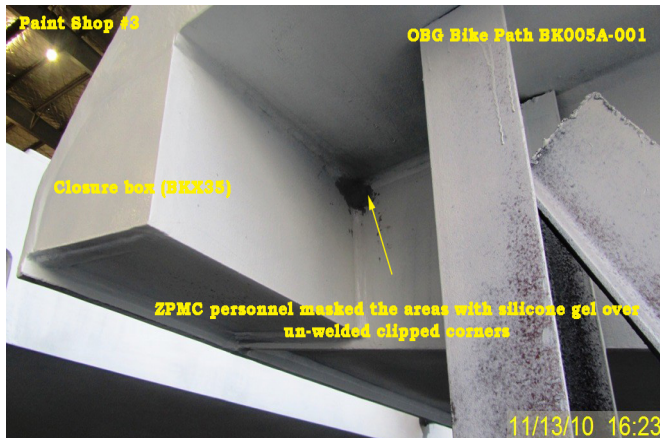
Description of Incident: During the Caltrans Quality Assurance in-process observations of the fabrication of Bike Path, this Quality Assurance Inspector (QA) observed that the welding at the corner of closure box (BKX35) was not continuous on the exposed ends of the closed box on each side. Shop drawing piece mark number (BKX35C) shows the location of the clipped corners. ZPMC personnel masked the areas with silicone gel over un-welded clipped corners. The closure box (BKX35) is welded to the bottom diaphragm plate (BKPL6A) and bearing plate (BKPL7A). The Bike Path Panel is identified as BK005A-001. The ZPMC QC is identified as Mr. Xu Tao. The material is identified as a Non Seismic Performance Critical Member (Non SPCM). This OBG Bike Path has been loaded onto the ship in preparation for shipment to the USA. See the attached pictures.

## Visual Inspection after Blast

### OBG Segment 12AE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 12AE, after the grit blast of the interior bottom side components of the side plate, bottom plates, floor beams and longitudinal diaphragm corner assemblies of this segment panel point PP111 to P112. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

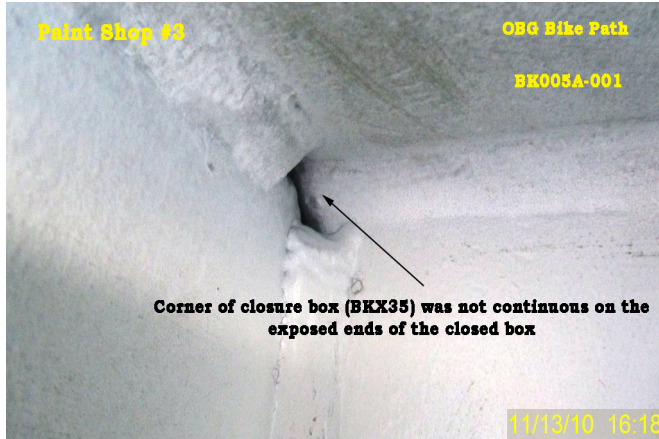


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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Vibin

Quality Assurance Inspector

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**Reviewed By:** Patel,Hiranch

QA Reviewer